

TRANSMITTAL FORM

Be used for all correspondence after initial filing)

Application Number	10/507,386
Filing Date	June 14, 2005
First Named Inventor	Erhardt et al.
Art Unit	2831
Examiner Name	Eric W. Thomas
Attorney Docket Number	14219-066US1

Total Number of Pages in This Submission

10

ENCLOSURES (check all that apply)

☐ Fee Transmittal Form

☐ Fee Attached

☐ Amendment / Reply

☐ After Final

☐ Affidavits/declaration(s)

☐ Extension of Time Request

☐ Express Abandonment Request

☐ Information Disclosure Statement

☐ Certified Copy of Priority Document(s)

☐ Reply to Missing Parts/
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under 37 CFR 1.52 or 1.53

☐ Drawing(s)

☐ Licensing-related Papers

☐ Petition

☐ Petition to Convert to a
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☐ Power of Attorney, Revocation
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☐ Appeal Communication to Group
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☐ Proprietary Information

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☒ Other Enclosure(s) (please identify
below):

Original Executed Combined
Declaration and Power of Attorney

Transmittal of Request for Certificate of
Correction (1 page)

Certificate of Correction (1 page)

Copy of Patent with mark up (5 pages)

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Remarks

Applicant submits herewith the Supplemental Declaration to substitute for the Declaration currently on file. In the Declaration currently on file, the U.S. Serial number and filing date were added post-signing..

SIGNATURE OF APPLICANT, ATTORNEY OR AGENT

Certificate

Firm Name Fish & Richardson P.C.

Signature

Printed Name Paul A. Pysher, Reg. No. 40,780

Date

OCT 23 2006

of Correction

October 16, 2006

CERTIFICATE OF TRANSMISSION/MAILING

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Name (Print/Type) Denise M. Donahue

Date

October 16, 2006

OCT 25 2006



IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant : Erhardt et al.
Patent No. : 7,016,178
Issue Date : March 21, 2006
Serial No. : 10/507,386
Filed : June 14, 2005
Title : CUP-SHAPED HOUSING AND CONDENSER WITH SAID HOUSING

Art Unit : 2831
Examiner : Eric W. Thomas

Attn.: Certificate of Corrections Branch
Commissioner for Patents
P.O. Box 1450
Alexandria, VA 22313-1450

TRANSMITTAL OF REQUEST FOR CERTIFICATE OF CORRECTION


Applicant hereby requests that a certificate of correction be issued for the above patent in accordance with the attached request.

One or more of the errors sought to be corrected were made by applicant, and a check for \$100 is enclosed to cover the required fee of 37 CFR §1.20(a).

Please apply any charges or credits to Deposit Account No. 06-1050 referencing Attorney Docket No. 14219-066US1.

Respectfully submitted,

Date: October 16, 2006


Paul A. Pysher
Reg. No. 40,780

Fish & Richardson P.C.
225 Franklin Street
Boston, MA 02110
Telephone: (617) 542-5070
Facsimile: (617) 542-8906

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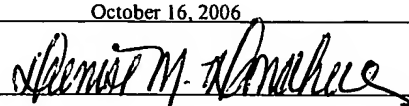
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UNITED STATES PATENT AND TRADEMARK OFFICE CERTIFICATE OF CORRECTION

Page 1 of 1

PATENT NO. : 7,016,178
APPLICATION NO : 10/507,386
DATED : MARCH 21, 2006
INVENTOR(S) : WERNER ERHARDT, HUBERTUS GOESMANN, GERHARD NIEDERBERGER, STEFAN
NOWAK AND KLAUS SCHOCH

It is certified that an error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Column 6, Claim 13, Line 61:
Insert - -and- - between "indentations" and "the"

MAILING ADDRESS OF SENDER:

Paul A. Pysher
Fish & Richardson P.C.
P.O. Box 1022
Minneapolis, Minnesota 55440-1022

SEP 25 2006.



SUPPLEMENTAL

COMBINED DECLARATION AND POWER OF ATTORNEY

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled CUP SHAPED HOUSING AND CONDENSER WITH SAID HOUSING, the English language specification of which:

- ☒ is attached hereto.
- ☒ was filed on September 10, 2004 as Application Serial No. 10/507,386.
- ☒ was described and claimed in PCT International Application No. PCT/DE03/00688 filed on March 4, 2003.

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose all information I know to be material to patentability in accordance with Title 37, Code of Federal Regulations, §1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate or of any PCT international application(s) designating at least one country other than the United States of America listed below and have also identified below any foreign application for patent or inventor's certificate or any PCT international application(s) designating at least one country other than the United States of America filed by me on the same subject matter having a filing date before that of the application(s) of which priority is claimed:

Country	Application No.	Filing Date	Priority Claimed
WIPO	PCT/DE03/00688	March 4, 2003	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No
Germany	20204027.5	March 13, 2002	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No

I hereby appoint the following attorneys and/or agents to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith:

Paul A. Pysher, Reg. No. 40,780
Frank R. Occhiuti, Reg. No. 35,306
Denis G. Maloney, Reg. No. 29,670

Alan D. Smith, Reg. No. 32,002
Mandy Jubang, Reg. No. 45,884
Timothy A. French, Reg. No. 30,175

Direct all telephone calls to PAUL A. PYSHER at telephone number (617) 521-5070.

Direct all correspondence to the following:

26161
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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patents issued thereon.

Attorney's Docket No.: 14219-066US1
Client's Ref. No.: P2002,0181 US N

Combined Declaration and Power of Attorney

Page 2 of 2 Pages

Full Name of Inventor: WERNER ERHARDT

Inventor's Signature: Werner ErhardtDate: 28 August 2006

Residence Address: Ballendorf, Germany

Citizenship: Germany

Post Office Address: Langestrasse 26
D-89177 Ballendorf
GERMANY

Full Name of Inventor: HUBERTUS GOESMANN

Inventor's Signature: Hubertus GoesmannDate: 28 August 2006

Residence Address: Auerndorf, Germany

Citizenship: Germany

Post Office Address: Morgenbacherweg 5
D-89564 Auerndorf
GERMANY

Full Name of Inventor: GERHARD NIEDERBERGER

Inventor's Signature: Gerhard NiederbergerDate: 28 August 2006

Residence Address: Gerstetten, Germany

Citizenship: Germany

Post Office Address: Drosselweg 3
D-89547 Gerstetten
GERMANY

Full Name of Inventor: STEFAN NOWAK

Inventor's Signature: Stefan NowakDate: 28 August 2006

Residence Address: Heubach, Germany

Citizenship: Germany

Post Office Address: Adler Str. 64
D-73540 Heubach
GERMANY

Full Name of Inventor: KLAUS SCHOCH

Inventor's Signature: Klaus SchochDate: 28 August 2006

Residence Address: Nattheim, Germany

Citizenship: Germany

Post Office Address: Wiedehopfweg 3
D-89564 Nattheim
GERMANY

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Specification

Cup-Shaped Housing And Condenser With Said Housing

5 Electrodes of electrochemical cells, such as capacitors or batteries, are frequently accommodated in cup-shaped housings. These housings are delimited by a bottom on one side and closed off with a lid on the other side. On the lid, there are generally two electrical connectors that serve for contacting the electrodes located in the interior of the cup-shaped housing. In this arrangement, conductors made of electrically conductive material are frequently either affixed to the electrodes, or projecting regions of the electrodes are trimmed in such a manner that projecting conductors are formed. These conductors are then connected with the electrical connectors either by means of screw connections (see Figure 1A) or connected rigidly by means of welding. Such contact between the electrodes and the electrical connectors is difficult to implement and, therefore, very time-consuming and thus also costly in production.

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 In another variant of cup-shaped housings for electrochemical cells, the electrodes are contacted via indentations having a rectangular cross-section, which are, for example, arranged on the inside walls of the lid and the housing bottom. In this case, the potential of the one electrode is applied to the housing cup, which must be insulated electrically from the lid, which has the potential of the other electrode applied to it. As is evident in Figures 2A and 2B, these indentations contact projecting regions of the electrodes,

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whereby as a rule only a small contacting area is present between the indentations and the electrodes. Such contact points are furthermore also frequently welded using a laser, for example. Since the laser beam is frequently cone-shaped in the region of the indentation, it is weakened at the outer edges of the indentation in the case of rectangular indentations so a very low input of energy of the laser into the interior of the indentation results, so that the indentation might be only insufficiently welded to the electrode (see Figure 2B, for example).

In this arrangement, in the case of capacitors and batteries, porous separators are frequently present between the two electrodes with different polarities, which separators are saturated with an electrolyte solution so that the two electrodes are in contact with the electrolyte solution.

Frequently, in the case of conventional housings, electrical insulations, e.g., plastic injection-molded parts, are present between the housing and the lid (see Figure 1A, for example) if different potentials are applied to the lid and the housing. Furthermore, sealing rings are also present in this arrangement, which form a tight seal between the housing and the lid so that the electrolyte solution cannot get into the environment. Such embodiments require an accordingly long and therefore cost-intensive assembly because of their complicated structure.

It is therefore the task of the present invention to provide a cup-shaped housing for

electrochemical cells that allows particularly simple contacting between the electrodes and the lid as well as the housing.

This task is accomplished via a housing according to claim 1. Advantageous embodiments of the housing are the object of dependent claims.

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The invention provides a cup-shaped housing for electrochemical cells having at least two electrodes, wherein the cup-shaped housing has a lid in which a first indentation, directed inwards, for contacting a first electrode, is formed, and in which a second indentation, directed inwards, for contacting a second electrode, is formed in the housing bottom. In this arrangement, the first and the second indentation have a cross-section that narrows into the interior of the housing.

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The advantage of a housing according to the invention is that because of the narrowing cross-section of the first and second indentation, a much larger contact area between the indentation and the electrodes than in the case of conventional housings is the result. Furthermore, via this special shape of the indentation, a maximal non-positive lock between the indentation and the electrodes is achieved. Because the cross-section of the indentations narrows into the interior of the housing, it is furthermore easily possible to allow a high input of energy into the indentation in the case that the contact point is welded via a laser beam, for example, so that the electrodes are melted together with the indentations particularly well (see also Fig. 3B, for example).

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In an advantageous embodiment of the housing, the first and the second indentation extend in a straight line over a large portion of an expanse direction of the lid and of the housing bottom. A housing structured in such a manner has the advantage that via the spatial expanse of the indentation, a particularly large contact area between the indentations and the electrodes is created.

In another variant of the housing according to the invention, the first and the second indentation are each formed by a separate component affixed to the inside of the lid or to the inside of the housing bottom, respectively. This can be done via welding or riveting, for example.

The material of housings according to the invention can comprise, for example, a number of aluminum alloys, for example aluminum 99.5 or aluminum 99.9, as well as aluminum forging alloys. The advantage of these materials is that they have good electrical conductivity, for one thing, so that the potential of the electrodes can be applied to them well, and that for another thing, they demonstrate good deformation properties, so they can be worked easily, hot or cold, for example via extrusion. In the case of housings according to the invention, made of this material, it is possible, for example, to form the first and second indentation via extrusion. In this manner, the indentations can advantageously be formed in one step with the housing and with the lid.

In another advantageous embodiment of a housing according to the invention, an electrically insulating component made in one piece is present that runs circumferentially around the lid and is arranged in a sealed manner between the lid and the wall of the housing (see Fig. 4A). Via this electrically insulating component, housings according to the invention can be sealed in a particularly simple manner, and, at the same time, the lid can be insulated electrically from the housing. Thus two functions (seal and electrical insulation) are integrated in a single component, in a particularly advantageous manner.

In contrast to conventional seals and insulations, which consist of two components, a particularly simple assembly of a housing according to the invention can be guaranteed by the one-piece electrically insulating component according to the invention, in the region of the lid.

In another embodiment, first regions of the electrically insulating component are arranged circumferentially around the lid, outside of the housing interior, whereby they have a notch into which the edge of the housing, towards the housing interior, is turned over circumferentially. In this arrangement, these regions with the notch allow particularly simple flanging of the housing and therefore a particularly reliable seal.

In this arrangement, the electrically insulating component can comprise rubber, e.g., acryl/nitrile/butadiene rubber.

In another embodiment, the invention describes an electrochemical cell that is a capacitor and, in this arrangement, has a cup-shaped housing according to the invention. A layer stack that comprises the first and the second electrode, formed as electrode layers in this case, is accommodated in the interior of the housing. Under some circumstances, a
5 flat separator saturated with an electrolyte solution can be located between the electrode layers. The faces of the layer stack lie opposite the lid and the housing bottom, respectively (see Figure 3A, for example). At the faces of the layer stack, edge regions of either the first or the second electrode layer, respectively, project and are turned over at the contact points with the indentations to increase the contact area. This means that
10 regions of the first electrode layer project out of the top face of the layer stack, for example, and regions of the second electrode stack project out of the face that lies opposite the housing bottom (see Figure 3A). The indentation located on the inside of the lid then contacts the projecting regions of the first electrode layer so that the potential of the first electrode layer is applied to the lid. The indentation formed in the housing
15 bottom then contacts the projecting regions of the second electrode layer so that the potential of the second electrode layer is applied to the housing cup.

It is advantageous if the contact points between the indentations and the electrode layers are welded. In this case, a particularly intimate contact between the indentations
20 and the electrode layers is the result. In this arrangement, the contact layers can be laser-welded. Because of the particular cross-sectional shape of the indentations, which narrows into the interior of the housing, a particularly high input of energy can be

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transferred at the weld points by laser beam so that particularly good welding can take place using a laser beam. The layer stack described here can also be rolled up to form a capacitor winding in this arrangement.

5 In the following, the invention will be explained in greater detail, using exemplary embodiments and figures.

Figure 1A shows a conventional capacitor that contains a layer stack that comprises electrode layers.

10 Figure 1B shows a conventional capacitor winding that can be accommodated in a housing.

Figures 2A and 2B show a conventional capacitor with indentations that have a rectangular cross-section, in cross-section and in detail.

15 Figures 3A and 3B show a capacitor with a housing according to the invention, in cross-section and in detail.

Figures 4A and 4B show a capacitor with another variant of a housing according to the invention, in cross-section and in a top view.

20 Figure 1A shows a capacitor with a conventional housing. In the capacitor housing 1, there is a layer stack that consists of a first electrode layer 16, a second electrode layer 17, and a separator 14 located between them. The separator is usually impregnated with an electrolyte solution. On the lid 5 of the housing 1, there are electrical

connectors 25, which contact the first and second electrode layer, respectively, by way of conductors 50, which are attached to the electrode layers. Such contacting of the electrical connectors with the electrode layers can only be implemented with a great deal of effort, as already described above.

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Instead of the layer stack shown in Figure 1A, a capacitor winding can also be introduced into the housing. In this arrangement, a first electrode layer 16, a separator 14, as well as a second electrode layer 17, are wound up around a core tube or around a mandrel, which leaves the hole 20 when it is removed. In this embodiment of the capacitor as well, the electrode layers, in each instance, can be contacted by way of projecting conductors 50.

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Figure 2A shows another embodiment of a capacitor having a conventional housing. It can be seen that a capacitor winding 15 is introduced into the housing 1, whereby the hole 20 that remains after removal of the core tube or the mandrel is located in the center of the capacitor winding 15. The lid 5 with the electrical connector 25 has an indentation 5a that is directed inwards and is rectangular in cross-section and contacts the projecting regions 16a of the second electrode layer 16. The capacitor lid therefore has the potential of the first electrode layer applied to it. In the housing bottom, there is a second indentation 10a, which is also rectangular in cross-section, whereby the latter contacts the projecting regions 17a of the second electrode layer 17. The housing cup therefore has the potential of the second electrode layer applied to it. For electrical

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insulation, an electrical insulation 6 is located between the housing cup and the lid.
Furthermore, a sealing ring 7 is present. In Figure 2B, the circle designated as 11 in
Figure 2a can be seen on a larger scale. It is evident that the second indentation 10a, in
this case, has only a very small contact area 17C with the projecting regions 17A of the
5 second electrode layer 17, because of the rectangular cross-section. Furthermore, the cone
30 of a laser beam is shown schematically. It is clearly evident that the outer edges 10B
of the indentation 10A project into the laser cone 30 and thereby reduce the energy input
of the laser into the indentation. Because of this reduction in energy input, the connection
between the indentation 10A and the contact area 17C with the projecting regions 17A of
10 the second electrode layer is not so good during welding.

Figure 3A shows a capacitor having a housing according to the invention. Both in
the lid 5 and in the bottom of the cup there are indentations 5B and 10B, respectively,
which are directed inwards. Both indentations have a cross-section that narrows towards
15 the inside. In Figure 3B, the circle designated as 12 in Figure 3A is shown on a larger
scale. It can be seen that because of the narrowing cross-section of the indentation 10B,
particularly large contact areas 17D between the indentation and the projecting regions
17A of the second electrode layer 17 are the result. In this arrangement, the projecting
regions of the electrode layers can be turned over at the contact point in such a manner
20 that possibly two or more electrode layers lie on top of one another and are compressed so
that particularly good contact between the indentation and the electrode layer is the result.
Furthermore, it is clearly evident that a cone-shaped laser beam 30 that is shown

schematically here is not weakened by the edges of the indentation, so that a particularly good energy input of the laser beam becomes possible and therefore a particularly good weld between the indentation and the contact points 17D with the projecting regions of the electrode layer is possible.

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Figure 4A shows a capacitor with another variant of a housing according to the invention. It can be seen that in this case, the indentations both in the lid and in the cup bottom are formed to be elongated. Because of this special shape of the indentations, a particularly large contact area between the indentations and the electrode layers is the result. Furthermore, an electrically insulating component 21 is present. This component 21 is arranged between the lid 5 and the wall of the housing 1, in sealed manner, and thereby at the same time insulates the lid electrically from the housing, and seals the housing. First regions 21A of the electrically insulating component are arranged outside the housing interior, circumferentially around the lid, and have a notch 21C into which the edge of the housing is turned over. Therefore it is possible to implement particularly easy flanging by means of the electrically insulating component 21. Furthermore, second regions 21B of the electrically insulating component are present in the interior of the housing, which regions are arranged between the wall of the housing and the projecting edge regions 16A of the first electrode layer. These regions 21B insulate the projecting edge regions of the electrode from the housing in a particularly simple manner. A circumferential indentation 26 in the form of a bead is formed in the wall of the housing, which bead in addition fixes the electrically insulating component 21 in place.

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In Figure 4B, the lid of the housing shown in Figure 4A can be seen in a top view. It is evident that six indentations 5B, arranged in star shape, are present in the housing lid, which indentations can produce a particularly intimate contact with the electrode layer.

5 Furthermore, one or more electrical connectors 25 are formed on the housing.

The invention is not limited to the exemplary embodiments shown here. Other variations are possible, both with regard to the number of indentations in the housing and with regard to their form. The electrodes that are contacted by means of the indentations

10 can also be configured differently. Thus, for example, not only the layer stacks shown but also windings or electrodes configured in another manner are possible.

Claims

1. Cup-shaped housing (1) for electrochemical cells, which have at least two electrodes (16, 17),

5 - having a lid (5) in which a first indentation (5B) for contacting a first electrode (16), directed inwards, is formed,

 - wherein a second indentation (10B) for contacting a second electrode (17) is formed in the housing bottom (10),

10 - wherein the first and the second indentation (5B, 10B) have a cross-section that narrows into the interior of the housing.

2. Housing as recited in the preceding claim,

 - wherein the first and the second indentation extend in a straight line over the major portion of an expanse direction of the lid and the housing bottom.

15 3. Housing as recited in one of the preceding claims,

 - wherein the first and the second indentation are formed of a separate component in each instance.

20 4. Housing as recited in one of the preceding claims,

 - wherein the material of the housing and the lid comprises aluminum or aluminum forging alloys.

5. Housing as recited in one of the preceding claims,

- wherein an electrically insulating component (21) made in one piece is present,

which runs circumferentially around the edge of the lid (5) and is arranged in sealed

5 manner between the lid (5) and the wall of the housing (1), for a seal and for electrical insulation.

6. Housing as recited in one of the preceding claims,

- wherein first regions (21A) of the electrically insulating component (21) are

10 arranged circumferentially around the lid (5), outside of the housing interior, and have a notch (21c),

- wherein the edge (1A) of the housing is turned over towards the housing interior, circumferentially around the lid, so that the turned-over edge is arranged within the notch of the electrically insulating component.

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7. Housing as recited in one of the preceding claims 5 or 6,

- wherein the electrically insulating component comprises rubber.

8. Electrochemical cell configured as a capacitor, having a cup-shaped housing

20 (1) as recited in one of the preceding claims, having the characteristics,

- a layer stack that comprises the first (16) and the second electrode (17), which are formed as electrode layers, is accommodated in the housing in such a manner that the

faces of the layer stack lie opposite the lid (5) and the housing bottom (10),

- edge regions of either the first (16A) or the second electrode layer (17A), in each instance, project out of the faces of the layer stack, and are turned over at the contact points with the indentations (5B, 10B), to enlarge the contact area.

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9. Electrochemical cell configured as a capacitor, having a cup-shaped housing (1) as recited in one of the preceding claims, having the characteristics,

- a layer stack that comprises the first (16) and the second electrode (17), formed as alternating electrode layers, is accommodated in the housing in such a manner that the faces of the layer stack formed by the outer edges of the electrode layers lie opposite the lid (5) and the housing bottom (10),

- edge regions of either the first (16A) or the second electrode layer (17A), in each instance, project out of the faces of the layer stack, and are turned over at the contact points with the indentations (5B, 10B), to enlarge the contact area,

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- second regions (21B) of the electrically insulating component (21) are present in the interior of the housing and are arranged between the wall of the housing and the turned-over edge regions of the first (16A) or the second electrode layer (17A), for electrical insulation.

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10. Capacitor as recited in the preceding claim,

- wherein the contact points between the indentations and the electrode layers are welded.

TRANSLATION

14219-066US1/ P2002,0181USN
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11. Capacitor as recited in the preceding claim,

- wherein the contact points are laser-welded.

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12. Capacitor as recited in one of claims 8 to 11,

- wherein the layer stack is rolled up into a capacitor winding.

Abstract

A housing (1) having a lid (5), for electrochemical cells having at least two electrodes is proposed, wherein indentations (5B, 10B) for contacting the electrodes are present both in the lid and in the housing bottom. In this arrangement, the indentations demonstrate a cross-section that narrows into the interior of the housing, so that a particularly large, easily welded contact area between the indentations and the electrodes is the result.

Fig. 4A



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FIG 1A Stand der Technik (Prior Art)

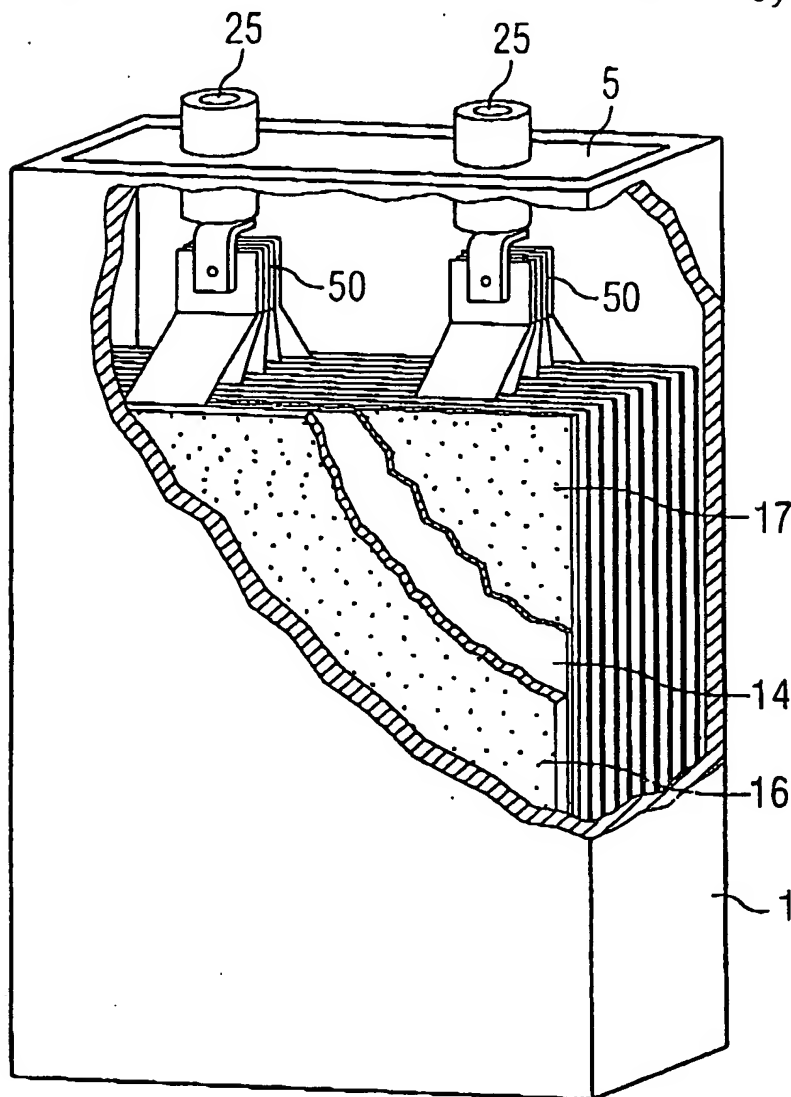
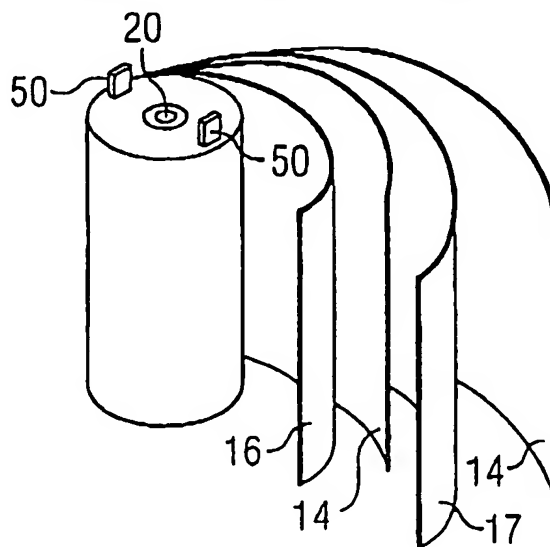


FIG 1B Stand der Technik (Prior Art)



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FIG 2A Stand der Technik (Prior Art)

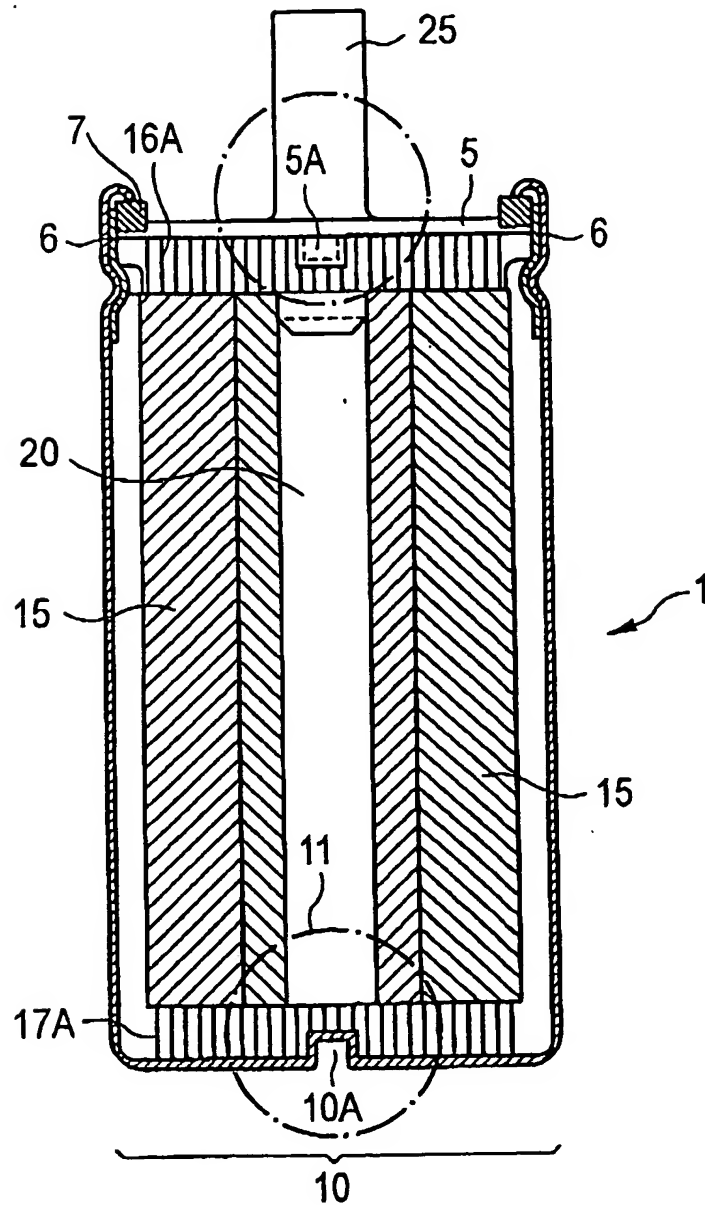
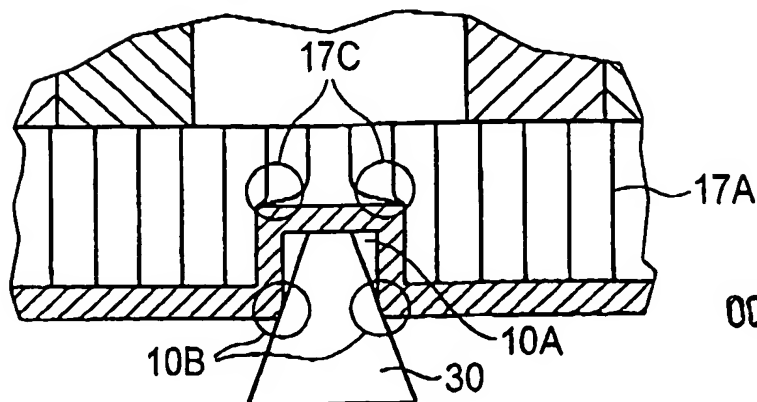


FIG 2B (Prior Art)



OCT 25 2006



US007016178B2

(12) **United States Patent**
Erhardt et al.

(10) **Patent No.:** **US 7,016,178 B2**
(45) **Date of Patent:** **Mar. 21, 2006**

(54) **CAPACITOR HOUSING**

(75) **Inventors:** **Werner Erhardt**, Ballendorf (DE);
Hubertus Goesmann, Auernheim (DE);
Gerhard Niederberger, Gerstetten
(DE); **Stefan Nowak**, Heubach (DE);
Klaus Schoch, Nattheim (DE)

(73) **Assignee:** **EPCOS AG**, Munich (DE)

(*) **Notice:** Subject to any disclaimer, the term of this
patent is extended or adjusted under 35
U.S.C. 154(b) by 0 days.

(21) **Appl. No.:** **10/507,386**

(22) **PCT Filed:** **Mar. 4, 2003**

(86) **PCT No.:** **PCT/DE03/00688**

§ 371 (c)(1),
(2), (4) **Date:** **Jun. 14, 2005**

(87) **PCT Pub. No.:** **WO03/079464**

PCT Pub. Date: **Sep. 25, 2003**

(65) **Prior Publication Data**
US 2005/0225926 A1 Oct. 13, 2005

(30) **Foreign Application Priority Data**
Mar. 13, 2002 (DE) 202 04 027 U

(51) **Int. Cl.**
H01G 2/10 (2006.01)
H01G 9/08 (2006.01)

(52) **U.S. Cl.** 361/517; 361/535

(58) **Field of Classification Search** 361/517-521,
361/535-540

See application file for complete search history.

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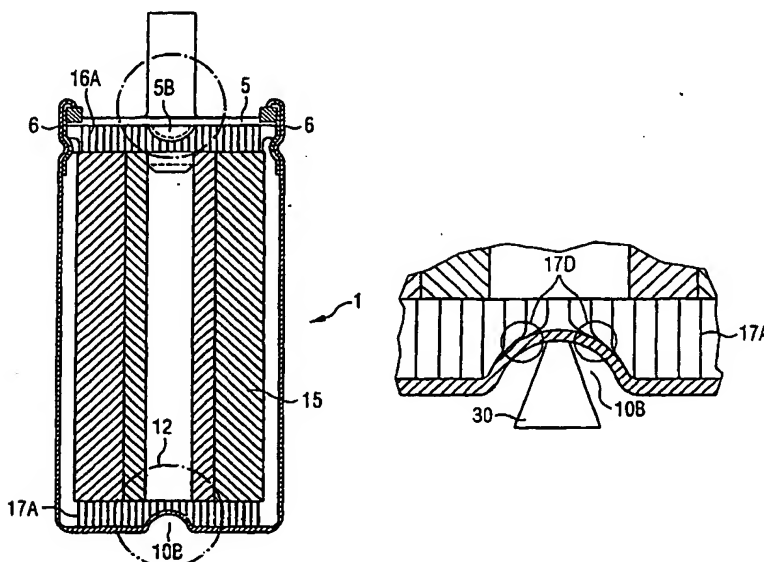
Primary Examiner—Eric W. Thomas

(74) *Attorney, Agent, or Firm*—Fish & Richardosn P.C.

(57) **ABSTRACT**

A housing for an electrochemical cell having at least a first electrode and a second electrode. The housing includes a lid having a first indentation to contact the first electrode, and a bottom having a second indentation to contact the second electrode. The first indentation has a first cross-section and the second indentation has a second cross-section. The first cross-section and the second cross-section get narrower as the first indentation and the second indentation progress into an interior of the housing.

20 Claims, 4 Drawing Sheets



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FIG 1A (Prior Art)

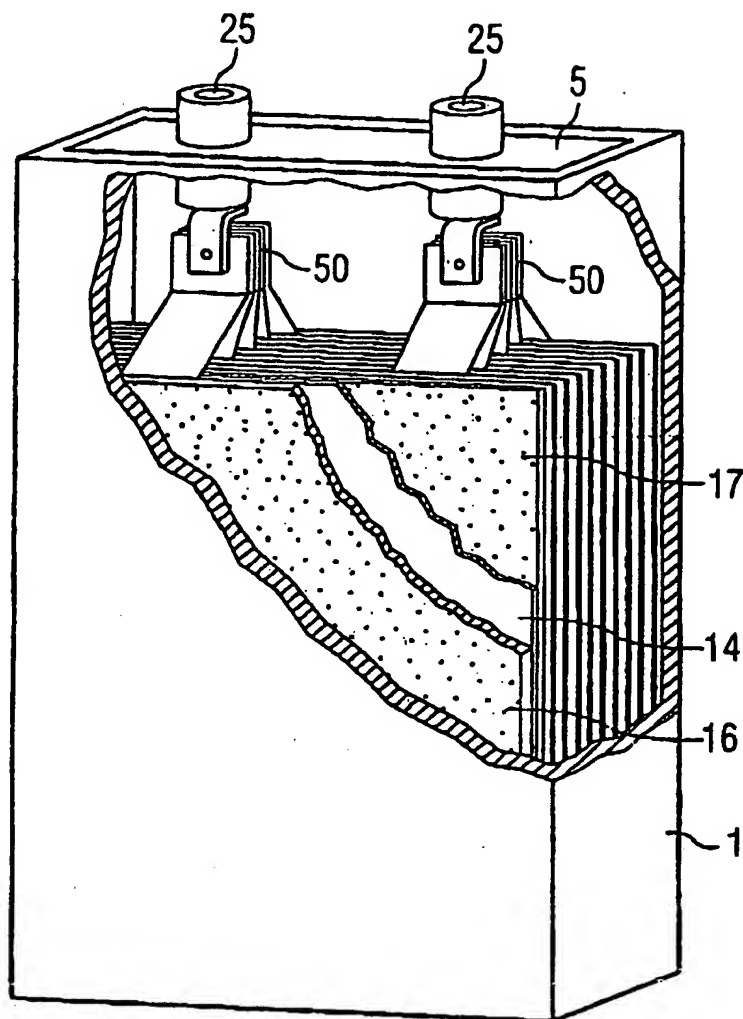


FIG 1B (Prior Art)

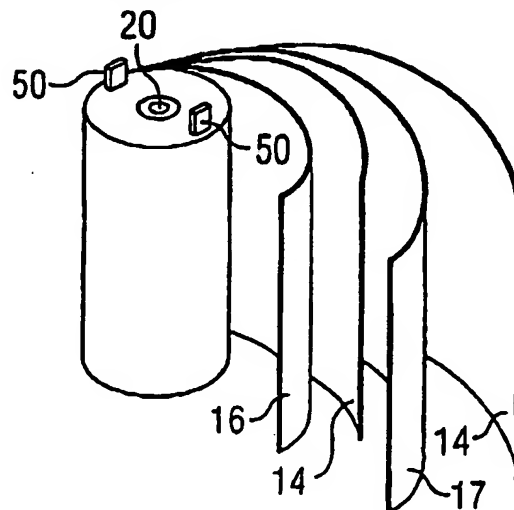


FIG 2A (Prior Art)

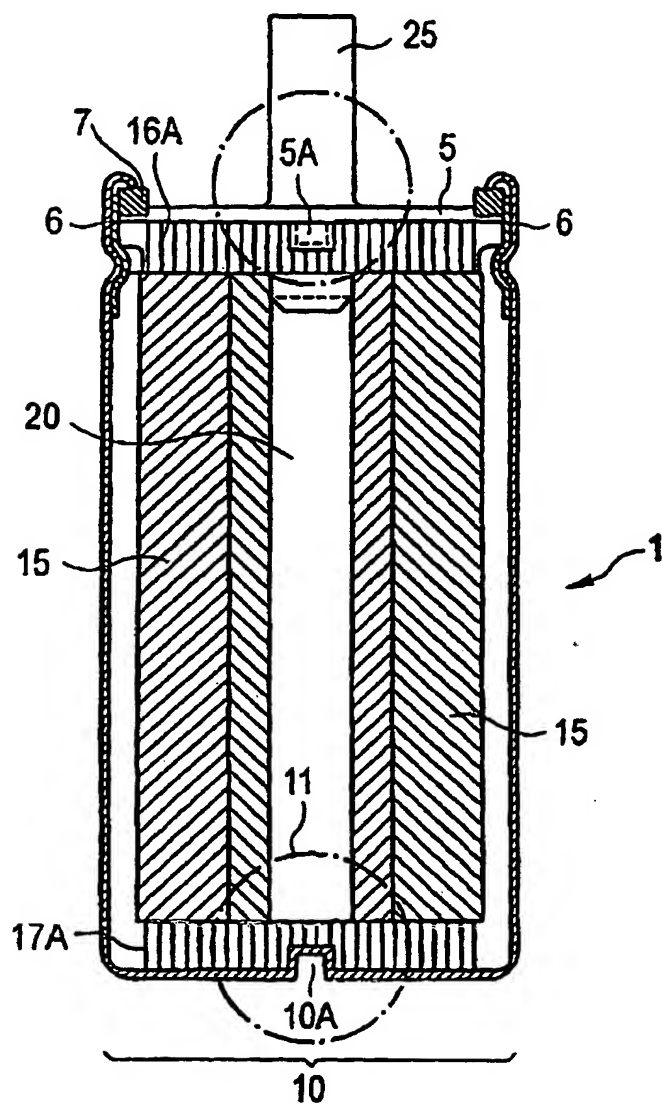


FIG 2B (Prior Art)

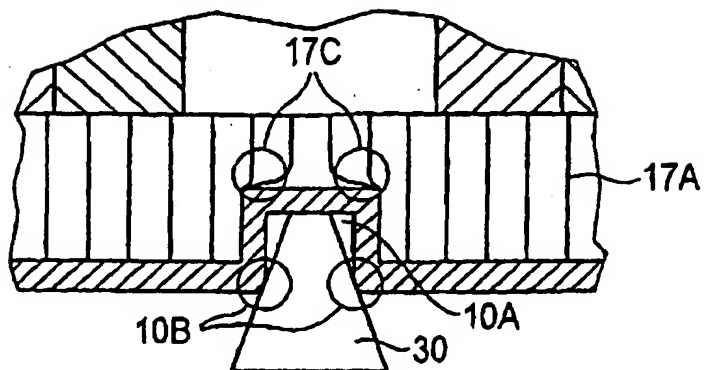


FIG 3A

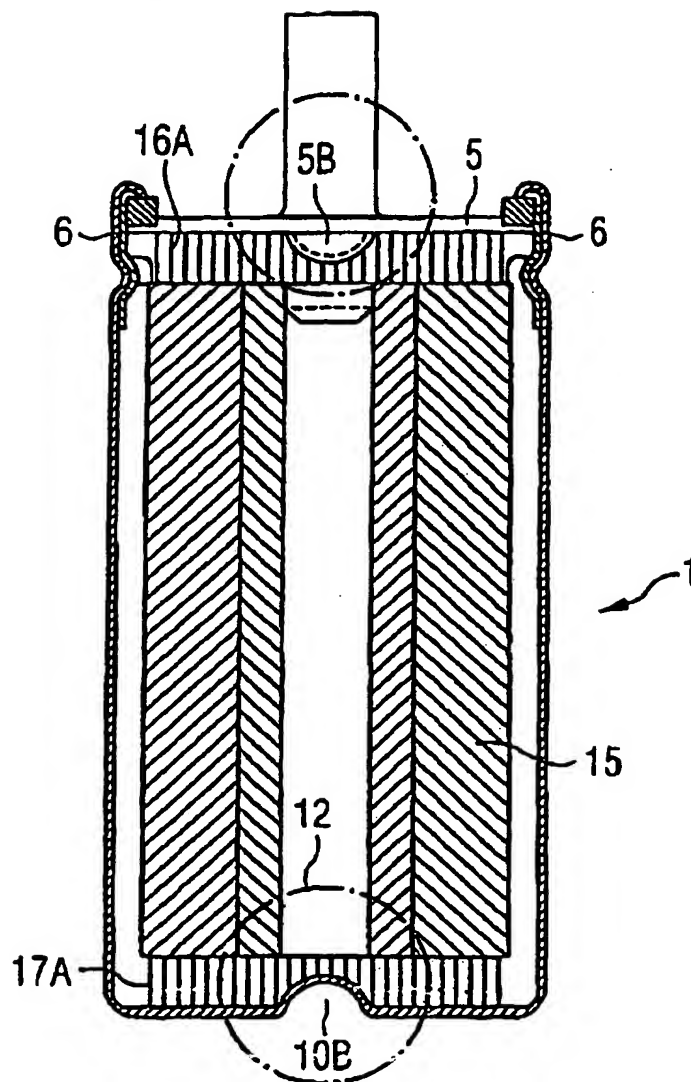


FIG 3B

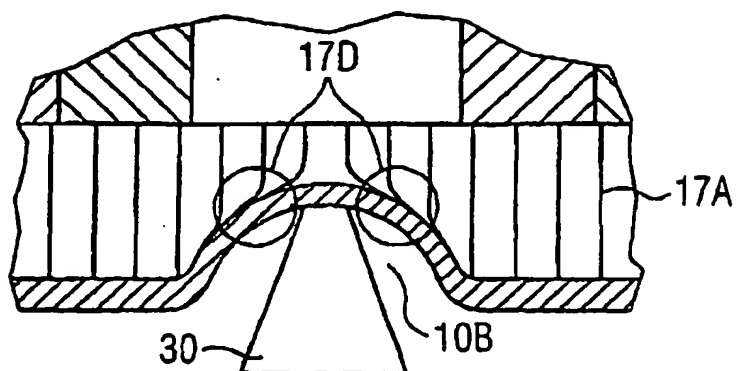


FIG 4A

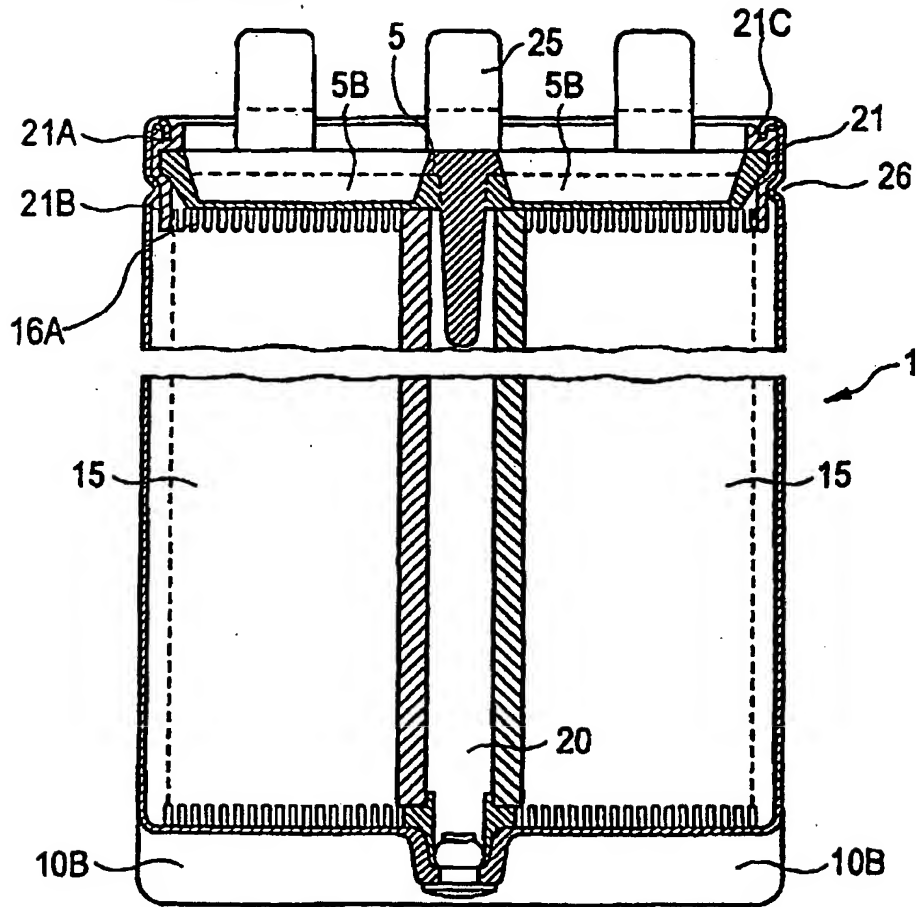
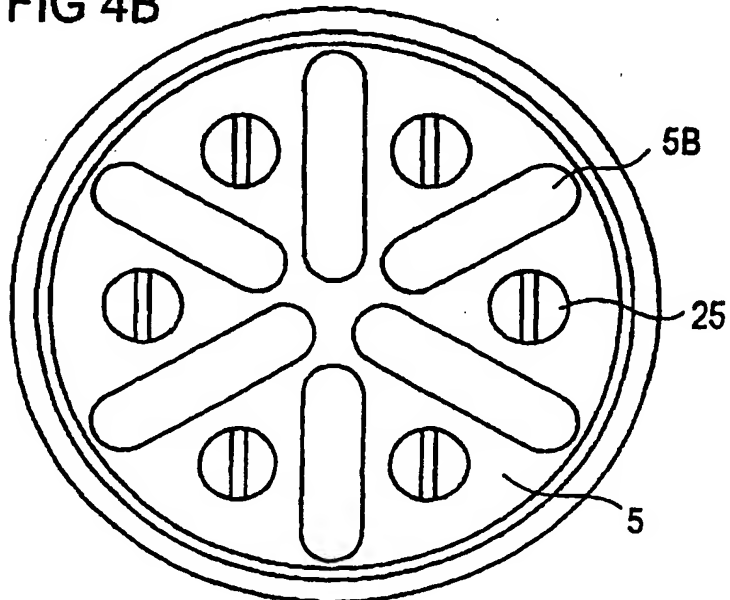


FIG 4B



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CAPACITOR HOUSING

BACKGROUND

Electrodes of electrochemical cells, such as capacitors or batteries, are frequently accommodated in cup-shaped housings. These housings are delimited by a bottom on one side and closed off with a lid on the other side. On the lid, there are generally two electrical connectors that serve for contacting the electrodes located in the interior of the cup-shaped housing. In this arrangement, conductors made of electrically conductive material are frequently either affixed to the electrodes, or projecting regions of the electrodes are trimmed in such a manner that projecting conductors are formed. These conductors are then connected with the electrical connectors either by means of screw connections (see FIG. 1A) or connected rigidly by means of welding. Such contact between the electrodes and the electrical connectors is difficult to implement and, therefore, very time-consuming and thus also costly in production.

In another variant of cup-shaped housings for electrochemical cells, the electrodes are contacted via indentations having a rectangular cross-section, which are, for example, arranged on the inside walls of the lid and the housing bottom. In this case, the potential of the one electrode is applied to the housing cup, which must be insulated electrically from the lid, which has the potential of the other electrode applied to it. As is evident in FIGS. 2A and 2B, these indentations contact projecting regions of the electrodes, whereby as a rule only a small contacting area is present between the indentations and the electrodes. Such contact points are furthermore also frequently welded using a laser, for example. Since the laser beam is frequently cone-shaped in the region of the indentation, it is weakened at the outer edges of the indentation in the case of rectangular indentations so a very low input of energy of the laser into the interior of the indentation results, so that the indentation might be only insufficiently welded to the electrode (see FIG. 2B, for example).

In this arrangement, in the case of capacitors and batteries, porous separators are frequently present between the two electrodes with different polarities, which separators are saturated with an electrolyte solution so that the two electrodes are in contact with the electrolyte solution.

Frequently, in the case of conventional housings, electrical insulations, e.g., plastic injection-molded parts, are present between the housing and the lid (see FIG. 1A, for example) if different potentials are applied to the lid and the housing. Furthermore, sealing rings are also present in this arrangement, which form a tight seal between the housing and the lid so that the electrolyte solution cannot get into the environment. Such embodiments require an accordingly long and therefore cost-intensive assembly because of their complicated structure.

SUMMARY

It is therefore the task of the present invention to provide a cup-shaped housing for electrochemical cells that allows particularly simple contacting between the electrodes and the lid as well as the housing.

This task is accomplished via a housing according to claim 1. Advantageous embodiments of the housing are the object of dependent claims.

The invention provides a cup-shaped housing for electrochemical cells having at least two electrodes, wherein the cup-shaped housing has a lid in which a first indentation,

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directed inwards, for contacting a first electrode, is formed, and in which a second indentation, directed inwards, for contacting a second electrode, is formed in the housing bottom. In this arrangement, the first and the second indentation have a cross-section that narrows into the interior of the housing.

The advantage of a housing according to the invention is that because of the narrowing cross-section of the first and second indentation, a much larger contact area between the indentation and the electrodes than in the case of conventional housings is the result. Furthermore, via this special shape of the indentation, a maximal non-positive lock between the indentation and the electrodes is achieved. Because the cross-section of the indentations narrows into the interior of the housing, it is furthermore easily possible to allow a high input of energy into the indentation in the case that the contact point is welded via a laser beam, for example, so that the electrodes are melted together with the indentations particularly well (see also FIG. 3B, for example).

In an advantageous embodiment of the housing, the first and the second indentation extend in a straight line over a large portion of an expanse direction of the lid and of the housing bottom. A housing structured in such a manner has the advantage that via the spatial expanse of the indentation, a particularly large contact area between the indentations and the electrodes is created.

In another variant of the housing according to the invention, the first and the second indentation are each formed by a separate component affixed to the inside of the lid or to the inside of the housing bottom, respectively. This can be done via welding or riveting, for example.

The material of housings according to the invention can comprise, for example, a number of aluminum alloys, for example aluminum 99.5 or aluminum 99.9, as well as aluminum forging alloys. The advantage of these materials is that they have good electrical conductivity, for one thing, so that the potential of the electrodes can be applied to them well, and that for another thing, they demonstrate good deformation properties, so they can be worked easily, hot or cold, for example via extrusion. In the case of housings according to the invention, made of this material, it is possible, for example, to form the first and second indentation via extrusion. In this manner, the indentations can advantageously be formed in one step with the housing and with the lid.

In another advantageous embodiment of a housing according to the invention, an electrically insulating component made in one piece is present that runs circumferentially around the lid and is arranged in a sealed manner between the lid and the wall of the housing (see FIG. 4A). Via this electrically insulating component, housings according to the invention can be sealed in a particularly simple manner, and, at the same time, the lid can be insulated electrically from the housing. Thus two functions (seal and electrical insulation) are integrated in a single component, in a particularly advantageous manner.

In contrast to conventional seals and insulations, which consist of two components, a particularly simple assembly of a housing according to the invention can be guaranteed by the one-piece electrically insulating component according to the invention, in the region of the lid.

In another embodiment, first regions of the electrically insulating component are arranged circumferentially around the lid, outside of the housing interior, whereby they have a notch into which the edge of the housing, towards the housing interior, is turned over circumferentially. In this

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arrangement, these regions with the notch allow particularly simple flanging of the housing and therefore a particularly reliable seal.

In this arrangement, the electrically insulating component can comprise rubber, e.g., acryl/nitrile/butadiene rubber.

In another embodiment, the invention describes an electrochemical cell that is a capacitor and, in this arrangement, has a cup-shaped housing according to the invention. A layer stack that comprises the first and the second electrode, formed as electrode layers in this case, is accommodated in the interior of the housing. Under some circumstances, a flat separator saturated with an electrolyte solution can be located between the electrode layers. The faces of the layer stack lie opposite the lid and the housing bottom, respectively (see FIG. 3A, for example). At the faces of the layer stack, edge regions of either the first or the second electrode layer, respectively, project and are turned over at the contact points with the indentations to increase the contact area. This means that regions of the first electrode layer project out of the top face of the layer stack, for example, and regions of the second electrode stack project out of the face that lies opposite the housing bottom (see FIG. 3A). The indentation located on the inside of the lid then contacts the projecting regions of the first electrode layer so that the potential of the first electrode layer is applied to the lid. The indentation formed in the housing bottom then contacts the projecting regions of the second electrode layer so that the potential of the second electrode layer is applied to the housing cup.

It is advantageous if the contact points between the indentations and the electrode layers are welded. In this case, a particularly intimate contact between the indentations and the electrode layers is the result. In this arrangement, the contact layers can be laser-welded. Because of the particular cross-sectional shape of the indentations, which narrows into the interior of the housing, a particularly high input of energy can be transferred at the weld points by laser beam so that particularly good welding can take place using a laser beam. The layer stack described here can also be rolled up to form a capacitor winding in this arrangement.

In the following, the invention will be explained in greater detail, using exemplary embodiments and figures.

DESCRIPTION OF THE DRAWINGS

FIG. 1A shows a conventional capacitor that contains a layer stack that comprises electrode layers.

FIG. 1B shows a conventional capacitor winding that can be accommodated in a housing.

FIGS. 2A and 2B show a conventional capacitor with indentations that have a rectangular cross-section, in cross-section and in detail.

FIGS. 3A and 3B show a capacitor with a housing according to the invention, in cross-section and in detail.

FIGS. 4A and 4B show a capacitor with another variant of a housing according to the invention, in cross-section and in a top view.

DETAILED DESCRIPTION

FIG. 1A shows a capacitor with a conventional housing. In the capacitor housing 1, there is a layer stack that consists of a first electrode layer 16, a second electrode layer 17, and a separator 14 located between them. The separator is usually impregnated with an electrolyte solution. On the lid 5 of the housing 1, there are electrical connectors 25, which contact the first and second electrode layer, respectively, by

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way of conductors 50, which are attached to the electrode layers. Such contacting of the electrical connectors with the electrode layers can only be implemented with a great deal of effort, as already described above.

Instead of the layer stack shown in FIG. 1A, a capacitor winding can also be introduced into the housing. In this arrangement, a first electrode layer 16, a separator 14, as well as a second electrode layer 17, are wound up around a core tube or around a mandrel, which leaves the hole 20 when it is removed. In this embodiment of the capacitor as well, the electrode layers, in each instance, can be contacted by way of projecting conductors 50.

FIG. 2A shows another embodiment of a capacitor having a conventional housing. It can be seen that a capacitor winding 15 is introduced into the housing 1, whereby the hole 20 that remains after removal of the core tube or the mandrel is located in the center of the capacitor winding 15. The lid 5 with the electrical connector 25 has an indentation 5a that is directed inwards and is rectangular in cross-section and contacts the projecting regions 16a of the second electrode layer 16. The capacitor lid therefore has the potential of the first electrode layer applied to it. In the housing bottom, there is a second indentation 10a, which is also rectangular in cross-section, whereby the latter contacts the projecting regions 17a of the second electrode layer 17. The housing cup therefore has the potential of the second electrode layer applied to it. For electrical insulation, an electrical insulation 6 is located between the housing cup and the lid. Furthermore, a sealing ring 7 is present. In FIG. 2B, the circle designated as 11 in FIG. 2a can be seen on a larger scale. It is evident that the second indentation 10a, in this case, has only a very small contact area 17c with the projecting regions 17a of the second electrode layer 17, because of the rectangular cross-section. Furthermore, the cone 30 of a laser beam is shown schematically. It is clearly evident that the outer edges 10b of the indentation 10a project into the laser cone 30 and thereby reduce the energy input of the laser into the indentation. Because of this reduction in energy input, the connection between the indentation 10a and the contact area 17c with the projecting regions 17a of the second electrode layer is not so good during welding.

FIG. 3A shows a capacitor having a housing according to the invention. Both in the lid 5 and in the bottom of the cup there are indentations 5b and 10b, respectively, which are directed inwards. Both indentations have a cross-section that narrows towards the inside. In FIG. 3B, the circle designated as 12 in FIG. 3A is shown on a larger scale. It can be seen that because of the narrowing cross-section of the indentation 10b, particularly large contact areas 17d between the indentation and the projecting regions 17a of the second electrode layer 17 are the result. In this arrangement, the projecting regions of the electrode layers can be turned over at the contact point in such a manner that possibly two or more electrode layers lie on top of one another and are compressed so that particularly good contact between the indentation and the electrode layer is the result. Furthermore, it is clearly evident that a cone-shaped laser beam 30 that is shown schematically here is not weakened by the edges of the indentation, so that a particularly good energy input of the laser beam becomes possible and therefore a particularly good weld between the indentation and the contact points 17d with the projecting regions of the electrode layer is possible.

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FIG. 4A shows a capacitor with another variant of a housing according to the invention. It can be seen that in this case, the indentations both in the lid and in the cup bottom are formed to be elongated. Because of this special shape of the indentations, a particularly large contact area between the indentations and the electrode layers is the result. Furthermore, an electrically insulating component 21 is present. This component 21 is arranged between the lid 5 and the wall of the housing 1, in sealed manner, and thereby at the same time insulates the lid electrically from the housing, and seals the housing. First regions 21 A of the electrically insulating component are arranged outside the housing interior, circumferentially around the lid, and have a notch 21C into which the edge of the housing is turned over. Therefore it is possible to implement particularly easy flanging by means of the electrically insulating component 21. Furthermore, second regions 21B of the electrically insulating component are present in the interior of the housing, which regions are arranged between the wall of the housing and the projecting edge regions 16A of the first electrode layer. These regions 21B insulate the projecting edge regions of the electrode from the housing in a particularly simple manner. A circumferential indentation 26 in the form of a bead is formed in the wall of the housing, which bead in addition fixes the electrically insulating component 21 in place.

In FIG. 4B, the lid of the housing shown in FIG. 4A can be seen in a top view. It is evident that six indentations 5B, arranged in star shape, are present in the housing lid, which indentations can produce a particularly intimate contact with the electrode layer. Furthermore, one or more electrical connectors 25 are formed on the housing.

The invention is not limited to the exemplary embodiments shown here. Other variations are possible, both with regard to the number of indentations in the housing and with regard to their form. The electrodes that are contacted by means of the indentations can also be configured differently. Thus, for example, not only the layer stacks shown but also windings or electrodes configured in another manner are possible.

What is claimed is:

1. A housing for an electrochemical cell having at least a first electrode and a second electrode, the housing comprising:

a lid having a first indentation to contact the first electrode; and

a bottom having a second indentation to contact the second electrode;

wherein the first indentation has a first cross-section and the second indentation has a second cross-section, the first cross-section and the second cross-section getting narrower as the first indentation and the second indentation progress into an interior of the housing.

2. The housing of claim 1, wherein the first indentation and the second indentation extend in substantially a straight line over the lid and the bottom, respectively.

3. The housing of claim 1, wherein the bottom and the lid are part of separate components.

4. The housing of claim 1, wherein the housing comprises aluminum or aluminum forging alloys.

5. The housing of claim 1, further comprising:

an electrically insulating component that is at least partly around an edge of the lid and that is between the lid and a wall of the housing.

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6. The housing of claim 5, wherein first regions of the electrically insulating component are arranged around a circumference of the lid and outside of an interior of the housing, the first regions having a notch; and

wherein an edge of the housing is turned towards an interior of the housing around the lid such that the edge is within the notch.

7. The housing of claim 5, wherein the electrically insulating component comprises rubber.

8. A capacitor comprising:

a housing comprising:

a lid having a first indentation, the first indentation having a first cross-section that gets narrower inside the housing; and

a bottom having a second indentation, the second indentation having a second cross-section that gets narrower inside the housing; and

a layer stack that comprises a first electrode layer and a second electrode layer, the layer stack having faces that are substantially opposite the lid and the bottom;

wherein an edge of at least one of the first electrode layer and the second electrode layer extends out of a face of the layer stack and is bent at contact points with at least one of the first and second indentations.

9. The capacitor of claim 8, wherein contact points between at least one of the first and second indentations and a corresponding electrode layer are welded.

10. The capacitor of claim 8, wherein the layer stack is rolled to produce a capacitor winding.

11. The capacitor of claim 8, wherein the housing further comprises:

an electrically insulating component that is at least partly around an edge of the lid.

12. A capacitor comprising:

a housing comprising:

a lid having a first indentation, the first indentation having a first cross-section that gets narrower inside the housing;

a bottom having a second indentation, the second indentation having a second cross-section that gets narrower inside the housing; and

an electrically insulating component that is around the lid;

a layer stack comprising alternating electrode layers including a first electrode layer and a second electrode layer the layer stack being disposed inside the housing such that faces of the layer stack formed by outer edges of the electrode layers are substantially opposite the lid and the bottom;

wherein an edge of at least one of the first electrode layer and the second electrode layer extends out of a face of the layer stack and is bent at contact points with at least one of the first and second indentations; and

wherein regions of the electrically insulating component are inside the housing between a wall of the housing and a bent edge of the first electrode layer or the second electrode layer.

13. The capacitor of claim 12 wherein contact points between at least one of the first and second indentations and the alternating electrode layers are welded.

14. The capacitor of claim 13 wherein the contact points are laser-welded.

15. The capacitor of claim 12 wherein the layer stack is rolled to produce a capacitor winding.

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16. The capacitor of claim 12, wherein second regions of the electrically insulating component are arranged around a circumference of the lid and outside of an interior of the housing, the first regions having a notch; and

wherein an edge of the housing is turned towards an interior of the housing around the lid such that the edge is within the notch.

17. The capacitor of claim 12, wherein the electrically insulating component comprises rubber.

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18. The capacitor of claim 12, wherein the first indentation and the second indentation extend in substantially a straight line over the lid and the bottom, respectively.

19. The capacitor of claim 12, wherein the bottom and the lid are part of separate components.

20. The capacitor of claim 12, wherein the housing comprises aluminum or aluminum forging alloys.

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